

AIR KITSAP COUNTY POLLUTION

DEC 1 1 1995

CONTROL AGENCY

AGCW-SEATTH FOUNTY

December 7, 1995

Gerry Brown Ash Grove Cement Co. 3801 E Marginal Way S Seattle, WA 98134

Dear Mr. Brown:

### Notices of Violation No. 33927, 33928, 33929

Enclosed are Notices of Violation No. 33927 (SO2, September 13, 1995), 33928 (NOx, September 1 and 4, 1995), and 33929 (NOx, October 12, 1995) for continuous emission monitoring results submitted for the months of September and October 1995 that exceeded permit conditions.

Now that the PSD permit has become finalized, this would be an appropriate time to make some minor modifications to the CEM-1 and CEM-2 forms. Three modifications that could be made include the following:

- 1. On future monthly CEM-2 reports, please include the actual times and average hourly readings for each hourly exceedance period for a measured pollutant, not just the number of hours of exceedance and the maximum value.
- 2. Please add a column on your NOx CEM-2 spreadsheet to be able to report the average hour or 24 hour CO, NOx and SO2 valves to demonstrate compliance with Order of Approval #5730 conditions #6 or #7.
- 3. Finally, please update the CEM-1 form by adding appropriate rows in the spread sheet that contains the emission standards in Order of Approval #5730 condition #6 or #7.

We could assist with details of the monthly information format upon receipt of a draft form.

Please contact me at 689-4055 or Elizabeth Gilpin at 689-4026 if you have any questions.

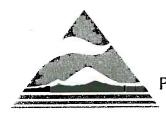
Sincerely,

Fred L. Austin
Air Pollution Engineer

FLA/cbc

Dennis J. McLerran, Air Pollution Control Officer

BOARD OF DIRECTORS



AIR

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CONTROL

AGENCY

KING COUNT

KITSAP COUNTY

PIERCE COUNTY

SNOHOMISH COUNTY

May 1, 1998 ECEIVED

MAY - 8 1996

AGCW-SEATTLE

Gerry Brown Ash Grove Cement Co. 3801 E. Marginal Way S. Seattle, WA 98134

Dear Mr. Brown:

### Disposition of Notice of Violation No. 33928 Registration No. 11339

Based on the information you provided to us in your corrective action letter dated February 15, 1996, this Agency considers the above-referenced matter closed and will take no further enforcement action in this case. We concur that the NOx excursion in September of 1995 was unavoidable per the WAC 173-400-107(6) excess emissions due to upsets.

If you have any questions concerning this matter, please contact me at 689-4078.

Neal J. Shulmun

Manager - Inspection

cc:

Rosemary G. Busterna, PSAPCA Elizabeth Gilpin, PSAPCA Fred L. Austin, PSAPCA

MM\cbc

Dennis J. McLerran, Air Pollution Control Officer

BOARD OF DIRECTORS

### PUGET SOUND AIR POLLUTION CONTROL AGENCY 110 Union Street, Suite 500, Seattle, Washington 98101-2038 Registration No. 206-343-8800 / 1-800-552-3565 / Fax 206-343-7522 No. 33928 Cert. Mail No. 20354 NOTICE OF VIOLATION Gerald Brown, Safety + Environmental Ash Grove Cement County Location of Violation (Address) Same DID UNLAWFULLY CAUSE OR ALLOW VIOLATION OF: OF THE PUGET SOUND AIR POLLUTION CONTROL AGENCY FOR: Failure to develop and implement an operation and maintenance plan. Section 5.05(e) Failure to obtain Notice of Construction approval prior to construction/installation/establishment of a source. Section 6.03(a) Failure to meet conditions of an Order of Approval. Section 6.09(b) Visible emissions in excess of 20% opacity for periods aggregating more than 3 minutes/hour. Section 9.03(a) Particulate matter deposited in quantities/characteristics/duration so as to be injurious or interfere with enjoyment of life/property. Section 9.04 Emission of air contaminant in quantities/characteristics/duration so as to be injurious or interfere with enjoyment of life/property. Section 9.11(a) Emission of odor-bearing air contaminants without use of best available control technology. Section 9.12(b) Emission of fugitive dust without use of best available control technology. Section 9.15(a) Operation of vehicle on paved public roadway with dirt/mud/debris on undercarriage (track out) or load spillage. Section 9.15(b) Emission of fugitive dust from manufacturing process equipment or control apparatus. Section 9.15(c) Failure to apply VOC-containing material using spray equipment in an enclosed area with filtered exhaust and vertical stack. Section 9.16 Failure to operate and maintain equipment in good working order. Section Order of Approval 5730 Condition 6 (b) which states that one hour average nitrogen exide emissions shall not exceed 700 ppm @ 10070 oxygen Section FACTS ALLEGED TO CONSTITUTE A VIOLATION ASh Grove CEM eport for data collected for September 1995 adings of 735.8 ppm on CORRECTIVE ACTION ORDER Under the provisions of Section 3.09 of Regulation I and RCW 70.94.211 you are ordered to submit a written report within ten (10) days of receipt of this Notice describing the necessary corrective action you have taken or propose to take, including a schedule, to achieve continuous compliance with the regulations, and take the following necessary corrective action:

10/7/05

Received By

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AGCS2M001111

# ASH GROVE CEMENT COMPANY

"WESTERN REGION"

February 15, 1996

Mr. Fred Austin,
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500
Seattle, WA. 98101-2038

Re: Notices of Violation 33928

Dear Mr. Austin,

Thank you for your February 2 letter requesting further information to determine exemption qualifications for the NOx emission which occurred on 09/04/95 as referenced in NOV #33928.

Regarding the NOx emission above the 1 hour limit of 700 ppmc. The emission was reported as the result of a mechanical failure and exempt under WAC 173-400-107 (6) Excess emissions due to upsets. The coal feeder for firing the kiln malfunctioned when a leak developed in the transport line. The coal feeder had to be shut down and firing of the kiln was switched to natural gas. This sudden switching of fuels caused an upset condition to occur in the kiln. The combination of firing the kiln with natural gas (which in general generates higher NOx than coal) and the upset condition in the kiln induced by a sudden fuel change generated the excessive NOx.

This event was not caused by inadequate design, operation or maintenance and there is no pattern of reoccurance as this is the first failure of this nature to occur at the Seattle Plant. Appropriate corrective action was taken to stabilize the kiln and to reduce kiln temperature. The problem was identified, repairs were completed and the feeder resumed operation.

Please let me know if you have any further question.

Yours trafy,

Gerald J. Brown

Manager Safety and Environment

Copy: Henrik Voldback

Nate Fernow Trygve Hille



**PUGET** KING COUNTY

AIR KITSAP COUNTY POLLUTION

CONTROL

AGENCY

SNOHOMISH COUNTY

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February 2, 1996

PIERCE COUNTY

FEB 0 5 1998

AGUW-SEATILE

Reg. No. 11339

Gerry Brown Ash Grove Cement Co. 3801 E Marginal Way S Seattle, WA 98134

Dear Mr. Brown:

### Notice of Violation No. 33928

We have reviewed your December 13, 1995 corrective action letter. In the letter you describe the September 4, 1995 NOx excursion as the result of an upset condition. However, you did not specify for which exemption you wish to qualify. Also, you need to give the criteria as to why this exemption applies to the particular event. Please submit this information to enable us to properly evaluate the excursion.

Thank you for your cooperation in this matter.

Sincerely, Frul L. Gustr

Fred L. Austin

Air Pollution Engineer

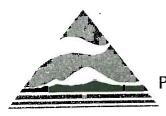
cc:

Elizabeth M. Gilpin, PSAPCA

Melissa McAfee, PSAPCA

EMG/cbc

Dennis J. McLerran, Air Pollution Control Officer DIRECTOR5 BOARD O F



AIR

**POLLUTION** 

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KING COUNTY

KITSAP COUNTY

PIERCE COUNTY

SNOHOMISH COUNTY

June 27, 1996

Reg. No. 11339

Henrik Voldback Ash Grove Cement Co. 3801 E Marginal Way S Seattle, WA 98134

Dear Mr. Voldback:

Notice of Violation No. 33927

Upon review of your letter dated December 13, 1995, the Agency learned that excess SO2 emissions occurred during startup instead of normal operations. Therefore, Notice of Violation No. 33927 cited for Order of Approval No. 5730, Condition 6(c) is rescinded. Please find enclosed Notice of Violation No. 35770 for Order of Approval No. 5730, Condition No. 7.

The Agency is still reviewing the enforcement status of this matter.

Sincerely,

Elizabeth M. Gilpin Air Pollution Inspector

**Enclosures** 

cc:

Rosemary G. Busterna, PSAPCA

Fred L. Austin, PSAPCA Melissa McAfee, PSAPCA

EMG/cbc

Dennis J. McLerran, Air Pollution Control Officer

BOARD OF DIRECTORS

### PUGET SOUND AIR POLLUTION CONTROL AGENCY 110 Union Street, Suite 500, Seattle, Washington 98101-2038 206-343-8800 / 1-800-552-3565 / Fax 206-343-7522 No. 33927 NOTICE OF VIOLATION Date of Violation: Ash Grove Cement Company Gerald Brown, Safety + Environments County City Location of Violation (Address) KING DID UNLAWFULLY CAUSE OR ALLOW VIOLATION OF: OF THE PUGET SOUND AIR POLLUTION CONTROL AGENCY FOR: REGULATION Failure to develop and implement an operation and maintenance plan. Section 5.05(e) Failure to obtain Notice of Construction approval prior to construction/installation/establishment of a source. Section 6.03(a) Failure to meet conditions of an Order of Approval. Section 6.09(b) $\Box$ Visible emissions in excess of 20% opacity for periods aggregating more than 3 minutes/hour. Section 9.03(a) Particulate matter deposited in quantities/characteristics/duration so as to be injurious or interfere with enjoyment of life/property. Section 9.04 Emission of air contaminant in quantities/characteristics/duration so as to be injurious or interfere with enjoyment of life/property. 0 Section 9.11(a) Emission of odor-bearing air contaminants without use of best available control technology. Section 9.12(b) Emission of fugitive dust without use of best available control technology. Section 9.15(a) Operation of vehicle on paved public roadway with dirt/mud/debris on undercarriage (track out) or load spillage. Ď Section 9.15(b) Emission of fugitive dust from manufacturing process equipment or control apparatus. Section 9.15(c) Failure to apply VOC-containing material using spray equipment in an enclosed area with filtered exhaust and vertical stack. Section 9.16 Failure to operate and maintain equipment in good working order. Section 9.20 Section Order of Approval 5730 datadom - Condition 6 cc) -average suther diaxide emissions shall not exceed 180 ppm at FACTS ALLEGED TO CONSTITUTE A VIOLATION ASH Grove CEM Monthly or September 1995 showing 5 hours of **CORRECTIVE ACTION ORDER** Under the provisions of Section 3.09 of Regulation I and RCW 70.94.211 you are ordered to submit a written report within ten (10) days of receipt of this Notice describing the necessary corrective action you have taken or propose to take, including a schedule, to achieve continuous compliance with the regulations, and take the following necessary corrective action:

12/7/95

mon 1/10

# ASH GROVE CEMENT COMPANY

"WESTERN REGION"

December 13, 1995

Mr. Fred Austin, Puget Sound Air Pollution Control Agency 110 Union Street, Suite 500 Seattle, WA. 98101-2038

Re: Notices of Violations 33927, 33928, 33829

Dear Mr. Austin,

During the transition period to the new limits specified in Order of Approval # 5730, unintentional errors in reporting occur. Most of which are corrected prior to the report being submitted but a few have been missed which do not clearly identify the operational phase or condition at the plant. Such errors we believe are responsible for PSAPCA's issuance of the above Notices of Violations. Further explanation is made below to clarify these reports.

### **NOV 33927**

The CEM report for September 1995 showed that on 9/13 there were five hours in excess of the 180 ppmc 1 hour average limit for SO2. These hours reflect the periods in excess of the old 33 ppmc limit not the new limits. Further, they occurred during startup where the emission concentration is limited to 200 ppmc. The values in question for this period are:

72 ppmc 07:00 - 08:00

08:00 - 09:00 217 ppmc 09:00 - 10:00 325 ppmc

51 ppmc 10:00 - 11:00

35 ppmc 12:00 - 13:00

Please note, that feed was put on the kiln at 10:00. Before this time, the kiln was in a preheat phase with minimal air flow passing through the system. During preheat, there is only about 15% of the normal airflow in the system This low airflow does not allow scrubbing agents to be added to the airstream. The mass flow for the two hours over 200 ppm were 42 lb/hr and 62 lb/hr. Thus there is no way to effectively control emissions during the preheat phase of startup.

### **NOV 33928**

This NOV sites two incidences where the hourly NOx exceeded the new 700 ppmc limit. The first occurred 9/1/95 between 16:00 and 17:00 with a value of 736 ppmc. The addendum however failed to identify the operating condition in which it occurred as kiln startup. Feed was put on the kiln at 12:20 that day. This would fall under condition #7 in which the limit is 1000 ppmc.

There were two hours on 9/4/95 in which the hourly NOx average exceeded 700 ppmc:

14:00 - 15:00 814 ppmc

15:00 - 16:00 847 ppmc

These exceedances were due to a process equipment malfunction. The powdered coal feeder which delivers the fuel to the kiln system developed a leak and had to be shut down and the system switched to natural gas. These two hours were caused by equipment malfunction and should be exempt from penalty.

### **NOV 33929**

The NOV sites two hours exceeding the 700 ppmc hourly limit for NOx on 10/12/95. The values for these hours are:

01:00 - 02:00 761 ppmc

02:00 - 03:00 787 ppmc

Although the addendum to the October report stated that exceedances occurred during startup, the date reported was 9/4 instead of 10/12. The kiln was in startup during this time as feed had been put on the kiln at 00:45. Condition #7 should apply as the concentration did not exceed the 1000 ppmc limit for startup.

I apologize for this miscommunication and any inconvience it may have caused.

Yours truly,

Gerald J. Brown

Manager Safety and Environment

Copy: HV

NF

DH

## Responses to PSAPCA NOV's

### NOV 33927

The NOV sites five hours of SO2 levels over 180 ppmc. On the date if 9/13/95 there were five hours over the old 33 ppmc limit. Furthermore this was during a startup. The values in question are:

9/13/95	07:00 - 08:00	72 ppmc
	08:00 - 09:00	217 ppmc
	09:00 - 10:00	325 ppmc
	10:00 - 11:00	51 ppmc
	12:00 - 13:00	35 ppmc

It should be noted that feed was put on the kiln at 10:00. Before this the kiln was in a preheat mode with minimal airflow passing through the system. During this time there is only about 15% of the normal airflow in the system. This low airflow does not allow scrubbing agents to be added to the airstream. The mass flow emissions for the two hours over 200 ppm were 42 lb/hr and 62 lb/hr. Thus there is no way to effectively control emissions during the preheat period.

### **NOV 33928**

The NOV sites two incidences where the hourly NOx exceeded the new 700 ppmc limit. The first occured 9/1/95 between 16:00 - 17:00 with a value of 736 ppmc. This was during a startup. Feed had been put on the kiln at 12:20 that day. This would fall under condition #7 in which the limit is 1000 ppmc.

There were two hours on 9/4/95 in which the hourly NOx average exceeded 700 ppmc:

These were due to a process equipment malfunction. The powdered coal feeder which delivers fuel to the kiln system developed a leak and had to be shut down and the system switched to gas. These two hours should fall under the equipment malfunction clause and be exempt from penalty.

### **NOV 33929**

The NOV sites two hours exceeding the 700 ppmc hourly limit for NOx. The values for these two hours are :

10/12/95 01:00 - 02:00 761 ppmc

02:00 - 03:00 787 ppmc

The kiln was in startup during this time as feed had been put on the kiln at 00:45. Condition #7 should be in effect. These did not exceed the 1000 ppmc limit for the case.



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PIERCE COUNTY

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February 23, 1996

RECEIVED

Gerry Brown Ash Grove Cement Co.

3801 E Marginal Way S Seattle, WA 98134

Dear Mr. Brown:

Notice of Violation No. 33929

In response to your December 15, 1995 corrective action letter, we concur that the October 12, 1995, 1 p.m. - 2 p.m. and 2 p.m. - 3 p.m. NOx levels of 761 and 787 ppm respectively, occurred during start up. As a result, Notice of Construction No. 5730 is applicable. Since the 1,000 ppm NOx one hour standard was not exceeded, Notice of Violation No. 33929 is hereby rescinded.

Sincerely,

Jim Nolan

Director - Compliance

Jems Wolon

cc:

Elizabeth Gilpin, PSAPCA Melissa McAfee, PSAPCA Fred Austin, PSAPCA Rosemary Busterna, PSAPCA

MM/cbc

Dennis J. McLerran, Air Pollution Control Officer OF DIRECTOR5 BOARD

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# PUGET SOUND AIR POLLUTION CONTROL AGENCY

Form No. 70-119 (Revised 9/93)

110 Union Street, Suite 500, Seattle, Washington 98101-2038 206-343-8800 / 1-800-552-3565 / Fax 206-343-7522

NOTICE OF VIOLATION

No. 33929

112	Responsible Person, Tit	le	
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Tement Company	Gerald Br	own, Sag Man	lety d'Environne a gen
	City	Zip	County
	Seattle		KING-
	City, State		
			623-5596
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OF THE PUGE	T SOUND AIR POLLUTION C	ONTROL AGENC	71 1010
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CONTROL

**AGENCY** 

KING COUNTY

KITSAP COUNTY

PIERCE COUNTY

SNOHOMISH COUNTY

February 2, 1996

Gerry Brown Ash Grove Cement Co. 3801 E. Marginal Way S. Seattle, WA 98134

Dear Mr. Brown:

### Disposition of Notice of Violation No. 33929 PSAPCA Registration No. 11339

Based on the information you provided to us in your corrective action letter dated December 13, 1995, this Agency considers the above-referenced matter closed and will take no further enforcement action in this case.

If you have any questions concerning this matter, please contact me at 689-4053.

Sincerely,

James L. Nolan

Director - Compliance

EMG\cbc

cc:

Rosemary G. Busterna, PSAPCA Fred Austin, PSAPCA Melissa McAfee, PSAPCA

Dennis J. McLerran, Air Pollution Control Officer

BOARD OF DIRECTORS

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### **MEMO**

Date: February 26, 1996

FAX To: Ken Rone

Doug Hale

Copy: Henrik Voldbaek

# of Payes 5

From: G. J. Brown

Subject: December 1995 Monthly Report

In response to your request for clarification on following items noted in my December 1995 Monthly Report:

1. PSAPCA NOV#'s 33929; 33928; 33927:

The information in the attached AGC letter to Fred Austin PSAPCA, 12/13/95 should fully explain the oversights that were made in the 9/95 and 10/95 CEMS report.

To update you on this issue: PSAPCA response to the 12/13/95 AGC letter: NOV# 33929 was closed on 02/20/96 without further action and then rescinded on 02/23/96 (???); Additional information was requested on NOV# 33928 (See AGC letter 02/15/96 Re: NOV# 33928 in response to this request). No PSAPCA response on the NOV# 33927 issued for SO2 during preheat.

NOTE: In this, the saga continues..., a meeting with PSAPCA was held on 02/05/96 to discuss NOV#'s 34404 issued for SOx (during Kiln Preheat) and 34405 issued for NOx (claimed exempt due to equipment failure) to explain the reason these exceedances should be exempt from penalties under the WAC 173-400-107. In this meeting, PSAPCA further questioned our application of the WAC exemption cited in NOV #'s 34404 and 33927 since Permit #5730 contains start up limits for SO2. Further documentation was provided (See 02/15/95 AGC letter Re: NOV# 34404 and 34405). To date, PSAPCA questions if the start up limits for SO2 are high enough and we have restated to Jim Nolan, PSAPCA our reasons for the limits and when SO2 control can be used during start up.

### 2. CEMS emission limits for November 1995:

The <u>November 95 CEMS</u> emissions report (shown on page 7 of the December 95 monthly report) reflects the new emission limits as "pending." These limits were not officially change until the WA.DOE PSD revised permit became effective in December 95.